

Date: Friday, 13/02/2009 1:02:27 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 129 BRACKET
Job Number : 45789	
Estimate Number : 11643	
P.O. Number :	Part Number : D29902
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D2990 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33602	Material :
Written By :	Due Date : 20/02/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUD 09.02.13</u>	
Comment : Est. A01.31.01 New Issue EC est B 07.08.03 waterjet blank EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00
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Comment: Qty.: 0.9913 f(s)/Unit Total : 3.9652 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 109253 B 9-2-18

8

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per template DT8547 ****(run prog. DT8547)****

Dwg Rev: BLANKS

Prog Rev: BLANKS B 9-2-18

2-Deburr if necessary

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA107

J.F. / DIP 09/02/20

7

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / DIP 09/02/21

7

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

88 09/02/23

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2990-2 PAR #: NA Fault Category: Prod/Eng. Coordination NCR: Yes No DQA: D Date: 09/02/25
 Resolution: D2990-042 D412-630-012 Disposition: Scrap QA: N/C Closed: D Date: 09/02/25

NCR: <u>45789</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/20	3.0	1 st part is Scrap, 0.757" ϕ is at 0.813" (0.051" over tol.) and prog #6000 had to be revised because of origines problems R.C. program error	<u>[Signature]</u> 09/02/20	Scrap = No Replace. update program	<u>[Signature]</u> 09/02/20	<u>[Signature]</u> 09/02-23	<u>[Signature]</u> 09/02/23	<u>[Signature]</u> 09/02/23

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:27 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 129 BRACKET

Job Number: 45789

Part Number: D29902

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

(7)

FL 09/02/23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST151

SS 09/02/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



MF
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>HS789</u>
Description: STA 129 Bracket		Part Number: <u>D2990-2</u>
Inspection Dwg: D2990	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	0.757	✓			2 Place
0.438	+0.000/-0.001	0.438	✓			
Ø0.507	+0.000/-0.001	0.507	✓			
5.690	+/-0.005	5.688	✓			
R1.000	+/-0.010	1.000	✓			
1.420	+/-0.001	1.419	✓			
Ø0.191	+0.005/-0.000	0.192	✓			2 Place
0.608	+0.000/-0.001	0.608	✓			
2.654	+0.000/-0.001	2.654	✓			
0.125	+/-0.010	0.125	✓			
R0.062	+/-0.010	0.062	✓			
0.125	+/-0.010	0.125	✓			
0.250	+/-0.010	0.250	✓			
R0.125	+/-0.010	0.125	✓			
0.250	+0.000/-0.005	0.250	✓			
0.875	+0.000/-0.001	0.8745	✓			

Measured by: <u>DJP</u>	Audited by: <u>88</u>	Prototype Approval:	N/A
Date: <u>09/02/20</u>	Date: <u>09/02/23</u>	Date:	N/A

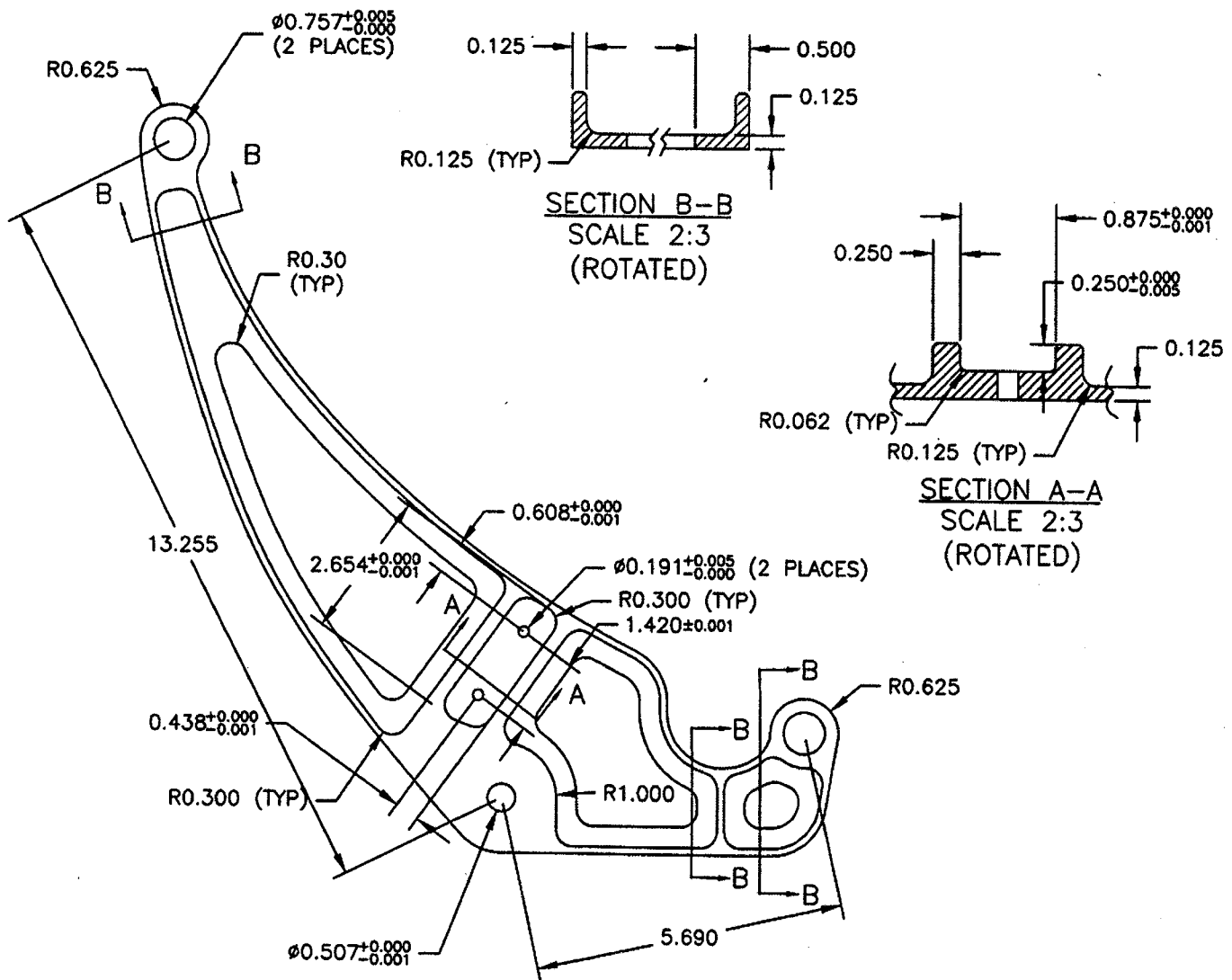
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.03.08	Dwg Rev. change	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
				D2990	SHEET 1 OF 2
DATE	05.01.20			TITLE	SCALE
				STA 129 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	05.01.20			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11

**D2990-1 BRACKET (SHOWN), D2990-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45789

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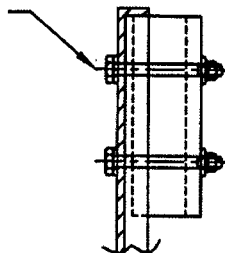
DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21		TITLE STA 129 BRACKET	SCALE 1:3

RELEASED

05.03.11 #

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2990-1 FOR D2990-041/-043
USE D2990-2 FOR D2990-042/-044

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT

SHOP COPY
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D2990-041/-043 BRACKET ASS'Y (SHOWN).
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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